

Friday, March 24, 2017 11:21:14 AM

Page 1

Quality Control

APR 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 158519

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158519

Page 2

Item ID: D412-711-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Reference Door Modification LH
Start Date: 3/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/11/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: scheduled/c

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021								
	Location: _____								
	PPP rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89
APR 11 2017DAS
21
9-89
APR 11 2017DAS
21
9-89
APR 11 2017

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Friday, March 24, 2017 11:21:13 AM

158519

D412-711-021

Required Date: 4/11/2017

Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-011		Manufactured	No			120	Each	0.0000	1	1			
D4324-011									**				
Armrest Assembly													
D412-761-043		Manufactured	No			120	Each	0.0000	1	1			
D412-761-043									**				
Modified Latch Mechanism, LH													
D412-711-101		Manufactured	No			120	Each	2.0000	1	1			
D412-711-101									**				
Replacement Vertical Reference Window													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG099		2							
				157134		1							
				157437		1							
D3802-1-120		Manufactured	No			120	Each	1.0000	1	1			
D3802-1-120									**				
Window Seal - 120"													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST639		1							
				157685		1							
D4165-1		Manufactured	No			120	Each	3.0000	1	1			
D4165-1									**				
Doubler													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		3							
				153518		3							

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4165-3 Manufactured No 120 Each 4.0000

D4165-3

Inner Door Panel

1 1 DAS 6 9-89 28 9-89

Location Loc Qty Loc Code

ST235 4

156490 4

D4165-5 Manufactured No 120 Each 3.0000

D4165-5

Aft Rib

1 1 DAS 6 9-89 28 9-89

Location Loc Qty Loc Code

ST236 3

153541 3

D4165-7 Manufactured No 120 Each 3.0000

D4165-7

Fwd Rib

1 1 DAS 6 9-89 28 9-89

Location Loc Qty Loc Code

ST236 3

116604 3

D4165-9 Manufactured No 120 Each 3.0000

D4165-9

Angle

1 1 DAS 6 9-89 28 9-89

Location Loc Qty Loc Code

ST237 3

153523 3

D4165-11 Manufactured No 120 Each 4.0000

D4165-11

Door Cover Panel

1 1 DAS 6 9-89 28 9-89

Location Loc Qty Loc Code

ST235 4

156380 4

APR 11 2017

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Shop Packet Print

Page 2

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Picklist Print

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4207-1 Manufactured No 120 Each 4.0000

D4207-1

Window Retainer

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST237

4

156413

4

D4207-3 Manufactured No 120 Each 4.0000

D4207-3

Instrument Window

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST237

4

156517

4

D4269-1 Manufactured No 120 Each 4.0000

D4269-1

Angle

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST089

4

143364

4

D4269-3 Manufactured No 120 Each 4.0000

D4269-3

Angle

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST089

4

156469

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Page 4

Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4269-5 Manufactured No 120 Each 3.0000 1 1

D4269-5

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

3

153604

1

158116

2

**

MAR 27 2017

DAS
28
9-89

D4269-7 Manufactured No 120 Each 3.0000 1 1

D4269-7

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

3

153605

1

158117

2

**

MAR 27 2017

DAS
28
9-89

D4327-1 Manufactured No 120 Each 4.0000 1 1

D4327-1

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

4

156398

4

**

MAR 27 2017

DAS
28
9-89

D4327-3 Manufactured No 120 Each 4.0000 1 1

D4327-3

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

4

156409

4

**

MAR 27 2017

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4385-1

Manufactured No

120

Each

7.0000

2

2

D4385-1

Placard

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST095

7

156112

6

147080

1

2/3/2017

6/13/2017

AN3-3A

Purchased No

120

Each

172.0000

22

22

AN3-3A

Bolt

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

50

m137061

50

ST350

122

m136741

6

m136851

16

m136975

100

AN3-4A

Purchased No

120

Each

251.0000

20

20

AN3-4A

Bolt

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST350

251

m136579

251

AN3-6A

Purchased No

120

Each

103.0000

26

26

AN3-6A

Bolt

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST350

103

153844

103

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

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Page 6

Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-12A Purchased No

120 Each

271.0000

1

1

AN3-12A

Bolt

**

MAR 27 2017

DAS 28
6 9-89

Location

Loc Qty

Loc Code

over003

206

153854

206

ST349

65

m135603

65

120

Each

2,765.000

92

92

**

MAR 27 2017

DAS 28
6 9-89

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

335

m133709

335

ST262

2430

m136835

630

m137075

1800

120

Each

169.0000

34

34

**

MAR 27 2017

DAS 28
6 9-89

CR3242-4-2

Purchased

No

CR3242-4-2

RIVET

Location

Loc Qty

Loc Code

CCK003

100

m137061

100

ST318

69

m134962

69

34

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-3

Purchased

No

120

Each

3,641.000

135

135

MS20426AD3-3

RIVET

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

fg108

40

M134946

200

M136880

40

GA

1010

M135274

1010

ST312

2391

M135274

2391

MS20426AD4-3

Purchased

No

120

Each

723.0000

140

140

MS20426AD4-3

Rivet

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

211

113064

211

ST312

512

m125807

512

MS20470AD3-3

Purchased

No

120

Each

6,073.000

25

25

MS20470AD3-3

RIVET, UNIVERSAL HEAD

**

MAR 27 2017

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

803

1065

803

ST310

5270

16941

5270

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-3

Purchased

No

120

Each

2,069.000

90

90

MS20470AD4-3

Rivet, Universal Head

**

MAR 27 2017

DAS 28 9-89
DAS 6 9-89

Location

Loc Qty

Loc Code

GA

894

2193

87

m135536

807

ST310

1175

m135536

1175

120

Each

1,647.000

24

24

**

90

DAS 28 9-89
DAS 6 9-89

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

213

m134360

102

M136665

111

OVER007

300

m134360

0

M136665

300

ST303

1034

M136554

33

M136838

1

m137073

1000

120

Each

116.0000

4

4

**

MAR 27 2017

DAS 28 9-89
DAS 6 9-89

MS21059L3

Purchased

No

MS21059L3

Nut Plate

Location

Loc Qty

Loc Code

ST301

116

M136835

51

M137073

65

DAS 27 9-89

4

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Work Order ID: 158519

158519

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 3/28/2017

Required Date: 4/11/2017

Start Qty: 1.00

Required Qty: 1.00

MS21069L3 Purchased No

120 Each

130.0000

34 34

MS21069L3

ANCHOR NUT

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

130

m136740

50

m136986

80

MS21069L08 Purchased No

120 Each

442.0000

8 8

MS21069L08

ANCHOR NUT

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

442

123522

442

MS21071L3 Purchased No

120 Each

54.0000

3 3

MS21071L3

ANCHOR NUT

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

54

125654

54

MS21071L08 Purchased No

120 Each

150.0000

1 1

MS21071L08

ANCHOR NUT

**

MAR 27 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299

150

102587

50

103447

100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
^1	^1	^1	^1	^1		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		* D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY
 ** PART OF EA20469-12 FWD RIB ASSEMBLY

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR NTS	
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
						1	204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1							D412-711-111	WIRING HARNESS, 212/412
B ₁							B ^D D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B ₁						B ^D D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B ₁					B ^E EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B ₁				B ^E EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B ₁			B ^D D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

- (A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041
(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210 Wiring Harnesses, use drawing D2046904.
For Bell 212 Wiring Harnesses, use drawing D2046903*.
For Bell 214 Wiring Harnesses, use drawing D214-761-511.
For Bell 412 Wiring Harnesses, use drawing D412-711-901.
For Bell 212 modified per SH07-28/SR02831NY use D212-761-224
or D212-761-225 depending on aircraft s/n.

* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft serial numbers

Wiring Harnesses will vary depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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Work Order ID 158519***158519***

Page 1

Monday, March 27, 2017 7:40:20 AM

Item ID: D412-711-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Reference Door Modification LH
Start Date: 3/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/11/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: scheduled/c

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711	L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels per PPP D412-711-021 CHG002								
120	Pick Kit	0.00							
120	Purchasing								
Packaging	Memo	0.00							
Packaging									
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

MAR 27 2017